

Work Order ID 81526

81526

Page 1

March-15-12 8:44:45 AM

Item ID: D1038-58B

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fastener Rail, Black

Start Date: 15/03/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D1038

Rev B

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create white labels and bag them

12-05-4

110

0.00

110

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

Bojo 12/04/07

50 Ø

120

0.00

120

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA783 Rev: AA & Dwg D1038 Rev: B
2-Deburr per dwg D1038

Bojo 12/04/08

50 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC2- Inspect parts off machine FAI/FAIB	0.00							
130									
QC	Memo	0.00	PD / 8.2	12/04/08		50	Ø		
Quality Control									
140	QC8- Inspect parts - second check	0.00							
140									
QC	Memo	0.00				50	Ø		36 12/04/08
Quality Control									
150		0.00							
150									
Small Fab	Small Fab	0.00				50	Ø		12/04/19
Small Fab	Memo								
Small Fab	Debur								

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Setup Start ***NS1***

Stop ***NS2***

Start Date: 15/03/2012 Start Qty: 50.00 ***50***

Required Date: 04/04/2012 Req'd Qty: 50.00 ***50***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC5- Inspect part completeness to step on W/O 0.00

160

QC Memo 0.00

Quality Control

50

2604/19

170 Outsource process-Anodize per QSI017 4.1.10.1 0.00

170

Outsource4 Memo 0.00

Outsource process - Anodize Issue P/O: 16779
Black Anodize as per Dwg D1038

CL 12/04/20 (50)

180 Receive & Inspect for Damage & Mat'l Certs 0.00

180

Packaging Memo 0.00

Packaging

CL 12/04/20 (50)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Required Date: 04/04/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		5.7/5/01		(auto) (x50)			
200 *200* Small Fab Small Fab	Small Fab Memo 1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389 Batch: <u>M120438</u> 2-Grind wire flush and deburr 3-Clean	0.00 0.00				50x			JS 12/05/03
210 *210* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				50			JS 12/05/04

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

0.00

220

Packaging

Packaging

Memo

0.00

Packaging

1-Pack each fastener rail into a cardboard tube
2-Roll Part in foam
3-Install red cap at each end and secure with tape.
4-Apply white labels to cardboard tubes
5-Identify and Stock
Location: EG 30

50x

Sp
12-05-07

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.00

Quality Control

12/5/8

1205-7

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Picklist Print

March-15-12 8:44:49 AM

Page 1

Work Order ID: 81526

81526

Parent Item: D1038-58B

D1038-58B

Parent Item Name: Fastener Rail, Black

Start Date: 15/03/2012

Required Date: 04/04/2012

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP: E 03.05.02 Reformat; Added label KJ/RF
 IPP Rev:F 06-08-16 Updated Packaging Procedures JLM
 IPP Rev:G 08-09-16 Added Folio # JLM Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2023		Manufactured	No			110	f	1,132.450	1.903	95.15			
D2023									**				
Extrusion, Fastener Rail												PO 12/04/07	

Location

Loc Qty

Loc Code

MAT006

1132.45

21907

1132.45

100.93

W/O:		WORK ORDER CHANGES					
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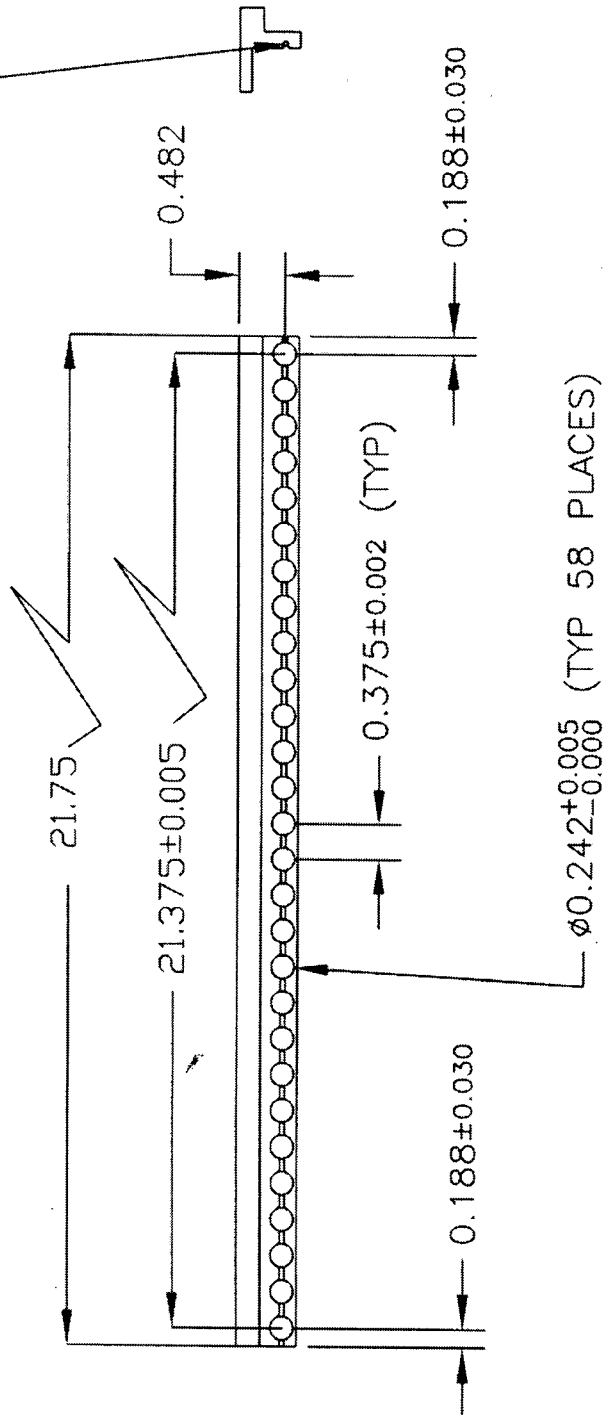


DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D1038	REV. B SHEET 1 OF 1
DATE 05.02.02	TITLE 1/4 TURN FASTENER RAIL		SCALE NTS
--	91.05.05	NEW ISSUE	
A	04.05.14	UPDATE TOLERANCE	
B	05.02.02	REDRAWN, UPDATE NOTES	

RELEASED

05.03.31 H

STAKE $\phi 0.50$ TYPE 302 STAINLESS
STEEL WIRE FULL LENGTH
(REF DART SPEC M302SW.050)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 01526 MLO
12/03/15

- D1038-58 1/4 TURN FASTENER RAIL
- 1) MAKE FROM D2023 EXTRUSION
 - 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16779

Purchase Order Date 4/20/12

PO Print Date 4/20/12

Page Number 1 of 1

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKALND, ON K4K 1T2
CANADA

Contact Name

Vendor Phone

613-446-4544

Vendor Fax

613-446-4556

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FXED
613-446-4544

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	81526	DI038-58B FASTENER RAIL	4/27/12 Yes	50.00	FedEx PI collect	\$1.8000	\$90.00

Special Inst: ANODIZE AS PER MIL-A-8625F TYPE I/IB
IC OR II OR IIB CLASS 2
BLACK ANODIZING

PO Total:

\$90.00

Change Nbr:

1

Change Date: 4/20/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable.

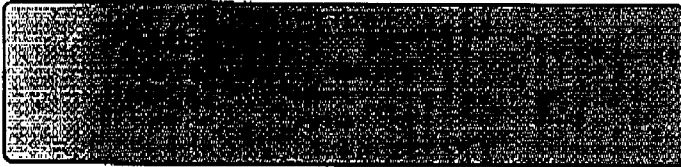
FROM

(THU) APR 26 2012 11:06/ST. 11:05/No. 6801242889 P 1

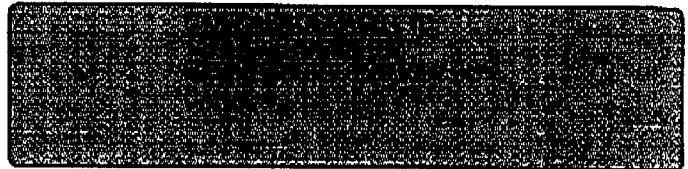


A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

To



Ship To



Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms	
Quantity	
50 ea	Part: D1038-58B Rev: BLACK ANODIZE MIL-A-8625 TYPE 2 CLASS 2 Job: 20120249 PO: 230868 Line: 81710514
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE: <u>24/9/12</u></p> <p>CERTIFIED SIGNATURE: <u>[Signature]</u></p> <p>RECEIVER SIGNATURE: _____</p>	